

Work Order ID 86737

July-06-12 11:48:19 AM

86737

Page 1

Item ID: D2654-7

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Web

Start Date: 7/06/12 Start Qty: 2.00

Cust Item ID:

Required Date: 8/03/12 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 12-07-12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2654	F								

100

0.00

100

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut D2600-7 to length as per Dwg D2654
2-Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654
3-Using the uni-bit, open holes to finish size as per Dwg D2654
4-Deburr holes and ends

110

Chemical Conversion Coat per QS1005 4.1

0.00

110

HandFinish

Memo

0.00

Hand Finishing

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

13-6-20

- DC 13/06/21

3E
13-06-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2654-7

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Web

Start Date: 7/06/12

Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/03/12

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
130	QC7	0.00				2	0	25	13/06/21
QC	Memo								
Quality Control									
140	Identify as per dwg & Stock Location: LG	0.00							
140		0.00				2	0	13	13/06/21
Packaging	Memo								
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150		0.00							
QC	Memo								
Quality Control									

MLJ 13-06-24

MLJ 13-06-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
13/06/24	130	change Qc3 to Qc7	SAD	13/06/24			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

July-06-12 11:48:19 AM

Page 1

Work Order ID: 86737

Parent Item: D2654-7

Parent Item Name: Web

Start Date: 7/06/12

Required Date: 8/03/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:D 99.02.04 Fixed typo, Changed procedureDM
IPP Rev:e 06.04.05 Added level21 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-7-125		Manufactured	No			100	Each	0.0000	1	2			
Extrusion 'I Beam' thick													

D2600-7-140 CY same as w/o: 84200

B 72279



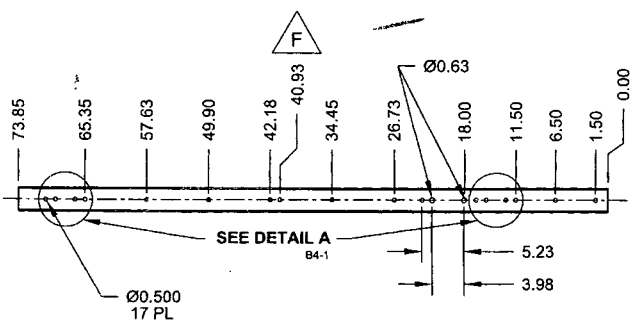
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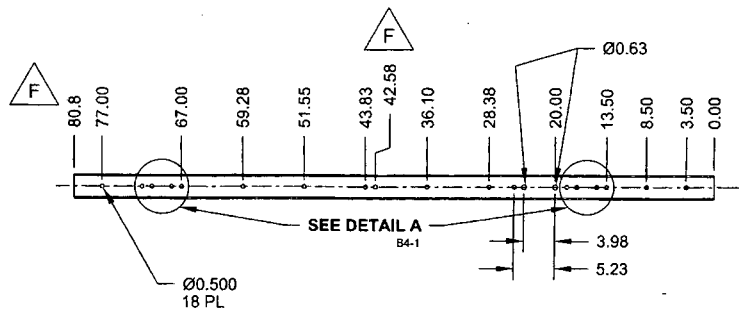
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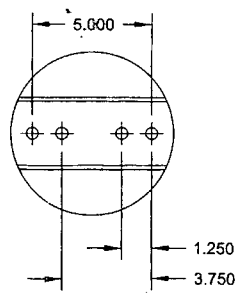
D2654-1 WEB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86737

PL 12-07-9



D2654-3 WEB



DETAIL A

C2-1
C3-1
C5-1
C8-1
D3-2
D6-2
B3-2
B6-2

RELEASED
2011-09-12

NOTES:

- 1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

REV.	DESCRIPTION	BY	DATE
F	ADDED ADDITIONAL HOLES ON -5/-7, 80.8 WAS 80.5, INCORPORATED DEO D2654-E-2	SC	11.05.05
E	CHANGE LENGTHS, REFORMAT	CP	04.05.26
D	GHW HOLES CHANGED TO Ø0.63	CP	98.01.15
C	CHANGED HOLE PATTERN	CP	97.10.29
B	ALTER HOLE PATTERN, 0.500 WAS 0.438	CP	97.06.26
A	NEW ISSUE	CP	97.03.25
DESIGN	CP	DATE	
DRAWN	SC		
CHECKED	<i>JP</i>		
MFG. APPR.	<i>BE</i>		
APPROVED	<i>JP</i>		
DE APPR.	<i>JP</i>		
DATE	11.05.05		

DART AEROSPACE USA, INC
PORT HADLOCK, WA
DRAWING NO. D2654
WEB
REV. F
SHEET 1 OF 2
SCALE
NTS

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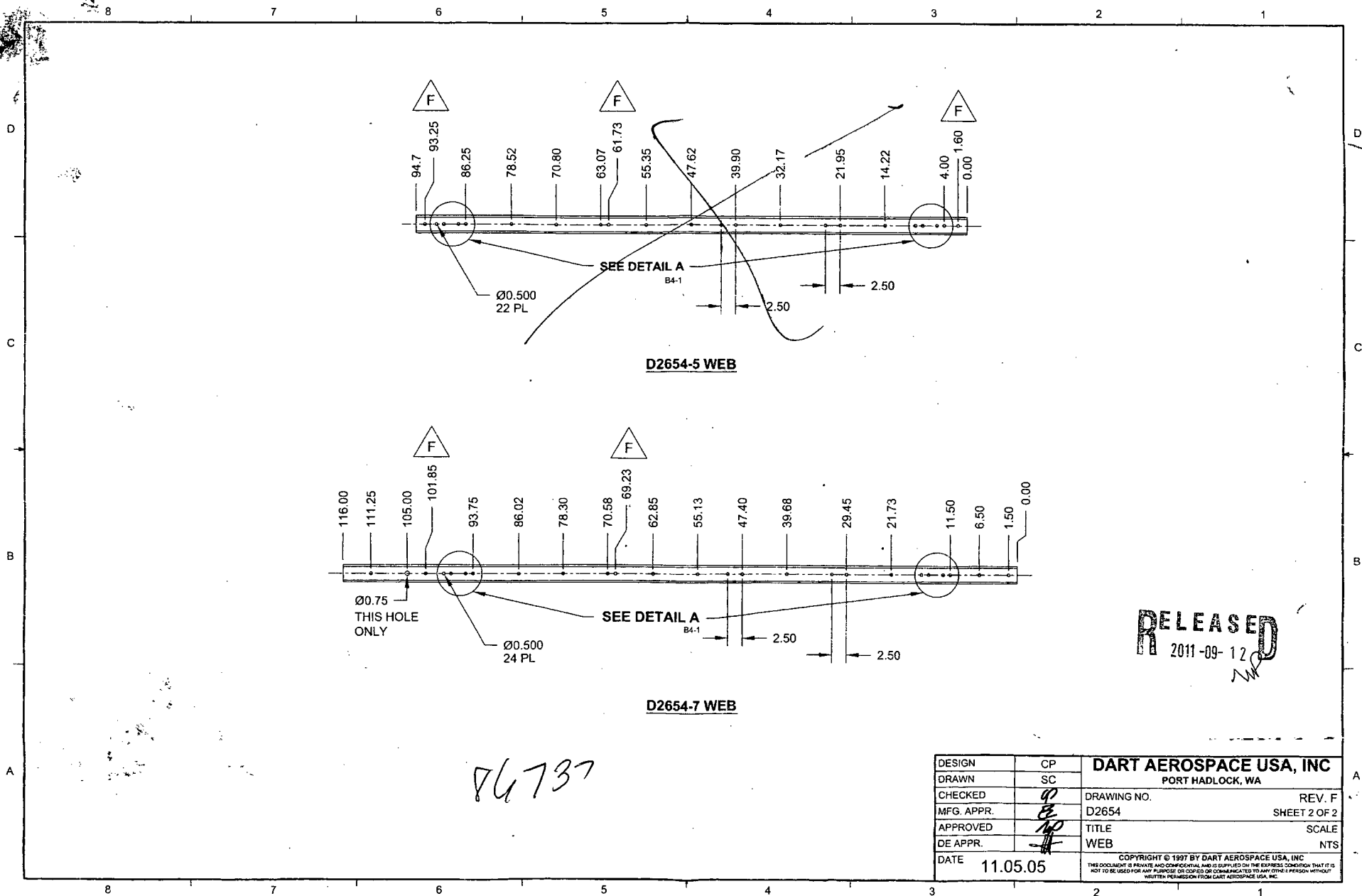
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RELEASED
2011-09-12

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>DP</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>BE</i>	D2654	SHEET 2 OF 2
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	WEB	NTS
DATE	11.05.05	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS LOANED TO YOU ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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